



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6795633

Job Sheet 196719



Part No: RB6795633

Job Qty: 1 pcs

Part Name: Attaching Gas Producer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 6/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16107

Note: DWG RB6795633 Rev B IPP Rev. A 19.06.13 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	Small Fab - 1	1 pcs	6/10/19		0.00	0.04	Small Fab - 1		
							Small Fab - 2		MCC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	6/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	6/10/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S209806



Part: RB6795633

Job No: 196719

Serial No/Batch: S209806

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 08/20/19

DATE

AUG 28 2019

40

9-89

Plex 6/20/19 10:10 AM Dart.lajeunesse.marie

https://www.plexonline.com/2ef6e9f5-e83d-4afb-8c0a-d4407a0e5035/Plexus_Control/Report_View/2.asp?URL=../Part/Job_Sheet.asp&Report=True...

1/2

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
130 QC 21 - FG	1 pcs	6/10/19	0.00 0.00		QC 21 - FG - 21	AUG 28 2019
					QC 21 - FG - 70	
					QC 21 - SA - 53	AUG 28 2019

Part Op 100 - Assemble as per DWG.
Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90293A139	17-4PH T-Handle Locking Quick Release Pin 1/4" Dia. X 1-3/4" Usable Length	1 Ea (1 ea)	100-Small Fab - 1	S196466
RB6795633-1	Plate	1 pcs (1 ea)	100-Small Fab - 1	S197124
RB6795633-2	Socket	1 pcs (1 ea)	100-Small Fab - 1	S200723

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90293A139	1	0	0
	RB6795633-1	1	0	0
	RB6795633-2	1	0	0

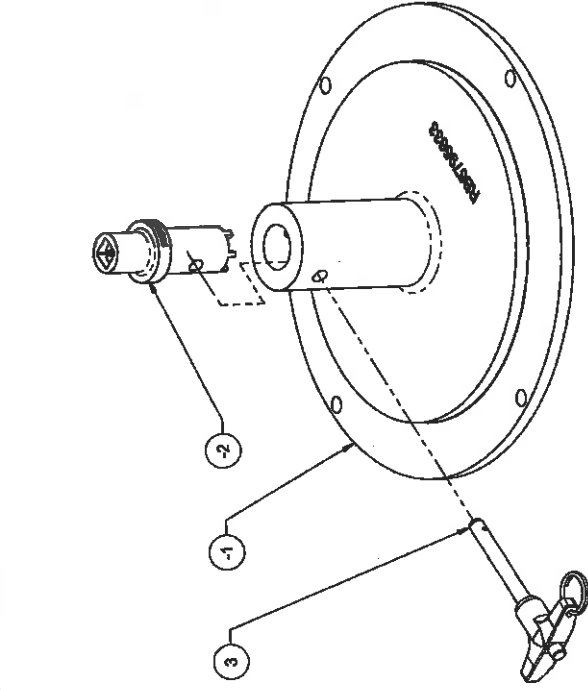
Part Specifications

Specifications could not be found.

60063
G4143F
@Mathieu

exactly

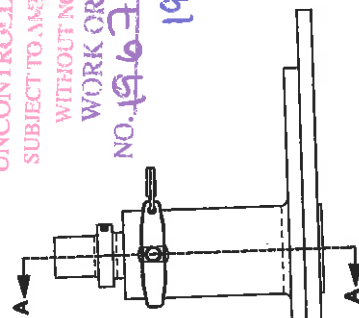
ITEM #	QTY	PART #	PART TITLE
-1	1	RB6795633-1	PLATE
-2	1	RB6795633-2	SOCKET
3	1	McMaster#90283A139 OR EQUIV	17-4PH T-HANDLE LOCKING QUICK-RELEASE PIN 1/4" DIA. X 1-3/4" USABLE LENGTH



RB6795633 ATTACHING GAS PRODUCER

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.05"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS SHOWN
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



SECTION A-A

B	SEE PREVIOUS FOR OLDER REV. TEMP. TREAT. FOR PART. PART. ITEM 1 WAS ASSY IS ITEM 2 PART. ITEM 3A A-38 DELETED. DIMENSION 0.250 X 0.061A CHANGED FOR 0.0257 THRU. DIMENSION 0.061A CHANGED FOR 0.0257 THRU 4 PL. DIMENSION 0.061A MAX 2 PL. ADDED. DIMENSION 0.125 CHANGED FOR 0.13. MATERIAL 6061 CHANGED FOR 6061-T6 / 7075-T6, FINISH FOR 6061-T6. BLACK ANODIZE CHANGED FOR RED ANODIZE. ITEM 2 MATERIAL 4140 CHANGED FOR 4140. DIMENSION 0.47 ADDED. DIMENSION 0.47 ADDED. DIMENSION 0.47 ADDED.		19-748	VM
	REV.	DESCRIPTION	ECN #	BY
DESIGN	VM			
DRAWN	VM			
CHECKED	KPT			
MFG. APPL.	JG			
APPROVED	W			
DATE	2019-06-12			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
TOOL PART #	RB6795633	SHEET 1 OF 3
TITLE	ATTACHING GAS PRODUCER	SCALE
DATE	2019-06-12	DATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196319 MJS
190620



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____		DEPARTMENT/PROCESS				MR8 (QS1042)	
Job: _____ Part No. _____		DISPOSITION		Eng. (Non-AW)		Engineering	
		Rework Scrap Use-as-is		Cross tube Small Fab Finishing		Water Jet Supplier Quality	
Date: _____		Sequence #: _____		Skid-tube Machining Large Fab		Prod. Eng. Coord. Rec/Store/Packaging	
Description Work Order Deviation		QTY Affected: _____		Disposition			
						Completed By	
						Lead hand / Supervisor	
						QC / QA Coordinator	
Root Cause		FAULT CATEGORY					
Operator		Contamination		Power Loss/ Surge		Positioned Wrong	
Manufacturing Process		Misaligned/off center		Folio/Program		Outside Tolerance	
Equip/Tooling		BOM/Route		Grain Direction		Drawing	
Handling/Preservation		Broken/Damage/Defect		Weld		Finish	
Material		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing	
Product Improvement		Drill Holes		Out of Sequence		Misread	
Process Improvement		Fit/Function		Off-set/Set-up			
Human Factors		Other/Details:					